

Work Order ID 63213

Monday, October 25, 2010 12:34:43 PM

Page 1

Item ID: D212-725-1-081F

Accept

Setup Start

Revision ID:

Stop

Item Name: Support

Start Date: 10/25/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-10-25 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D212-725-1

G

100

0.00



Waterjet

FLOW CNC Waterjet

304 .050

Memo

1-Cut as per Dwg

Dwg Rev: G

Prog Rev: G

2-Deburr if necessary

0.00

10-10-27

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

10-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

FLAT PATTERN ONLY

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



(4)

Cupps (4)

10/10/27

CL 10/10/27

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Picklist Print

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Page 1

Work Order ID: 63213



Parent Item: D212-725-1-081F



Parent Item Name: Support

Start Date: 10/25/2010

Required Date: 10/29/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S18GA

Purchased

No

100

sf

93.4200

0.1155

0.486316



13 10-10-27

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT20

93.42

111743

5.25

113062

40.17

115389

48

111743

④

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

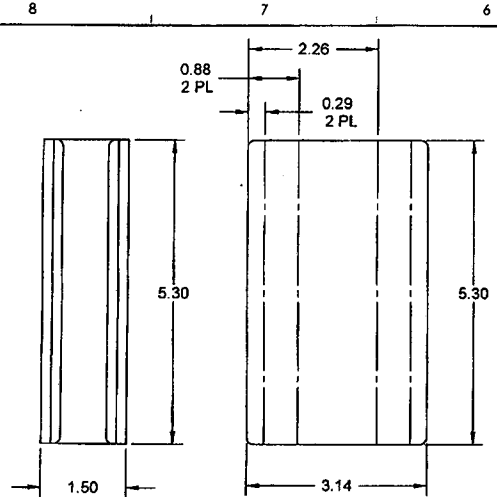
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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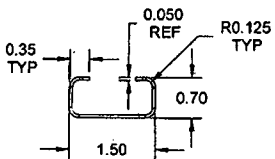
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

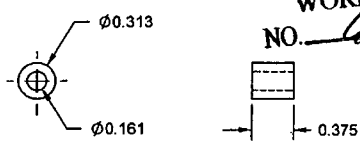
NO. 63213
2/10/05



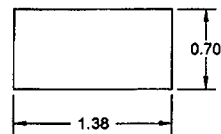
D212-725-1-081F FLAT PATTERN



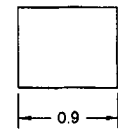
D212-725-1-081 SUPPORT
(MAKE FROM D212-725-1-081F FLAT PATTERN)



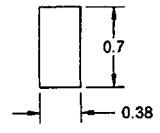
D212-725-1-101 SPACER



D212-725-1-095 RADIUS BLOCK



D212-725-1-097 PACKER



D212-725-1-099 RADIUS BLOCK

D212-725-1-095/-097/-099 NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF DART SPEC. M6061T6B
OR 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

D212-725-1-101 NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR ASTM B211 OR ASTM B221
REF DART SPEC. M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

D212-725-1-081 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED, 2B FINISH 0.050 (18 GAUGE) THICK
PER AMS-5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S18GA
- 2) FINISH: NONE

GENERAL NOTES:

- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

RELEASED

10.03.71

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<u>140</u>	DRAWING NO.	REV. G
MFG. APPR.	<u>140</u>	D212-725-1	SHEET 31 OF 84
APPROVED	<u>140</u>	TITLE	SCALE
DE APPR.	<u>140</u>	212S DETAIL PARTS	NTS
DATE	10.02.12	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR CONVEYED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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